

Date: Thursday, 11/9/2006 4:32:06 PM  
 User: Kim Johnston

## Process Sheet

SPLIT

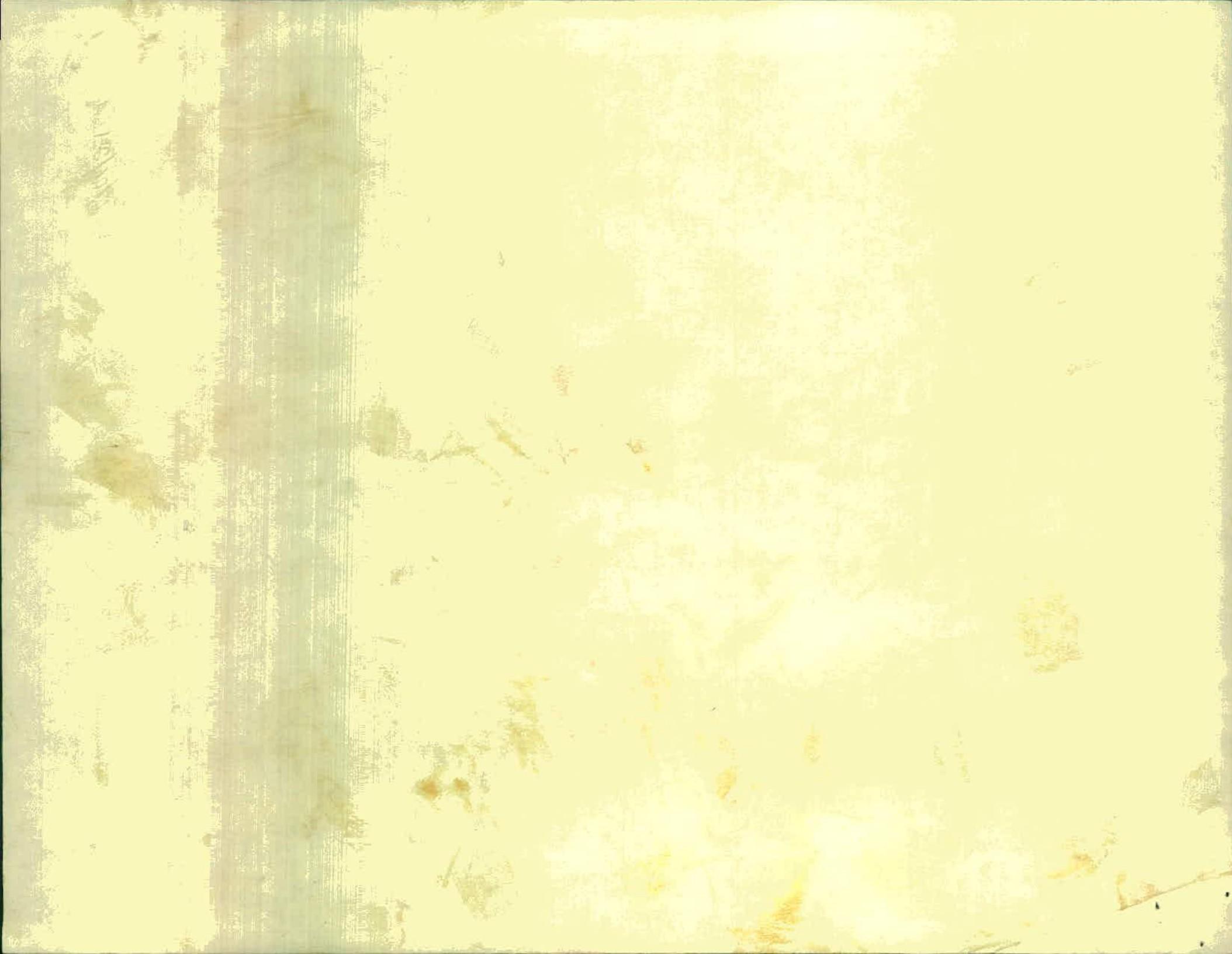
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG	
Job Number	: 29377		Part Number	: D22301	
Estimate Number	: 10255		Drawing Number	: D2230 REV F	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/9/2006	S.O. No. : N/A	Drawing Revision	: F	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/30/2006	
Previous Run	: 28902		Qty:	225	Um: Each
Written By	: <u>W</u>		Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC	
Checked & Approved By	: <u>061010</u>				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D2423	Lug Extrusion			
		Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s) 16.1325 Lug Extrusion D2423 Extrusion Batch: B23777		En ob(u),2	225
2.0	BAND SAW	BAND SAW			
		Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: B23779		En ob(u),2	225
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1			c20611113(225)
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling		Machine per Job D2230 Rev.F	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			07/01/24(125)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		Receive + Inspect for tensile damage	04/12/18 100
5.0	QC3	SECOND CHECK			02/01/24(125)
		Comment: SECOND CHECK Inspect level 5			



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Drawing Name: MOUNTING LUG

Job Number: 29377

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

218 / 100

COUNTED

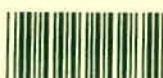
07-01-24 (125)

7.0 QC5

INSPECT WORK TO CURRENT STEP



ML 07 01 24



(125)

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



M103141



(125X)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M.A / 11

07/01/25

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

B 7/01/29



(125)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

21370

P 7/01/29



(125)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



(125)

Job Completion

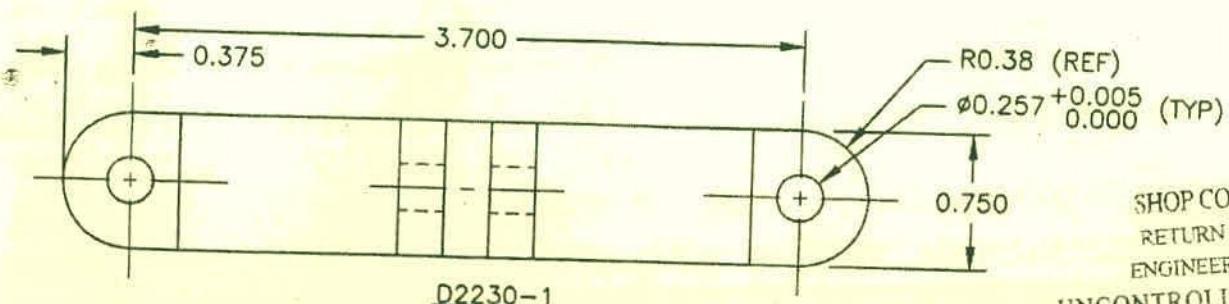
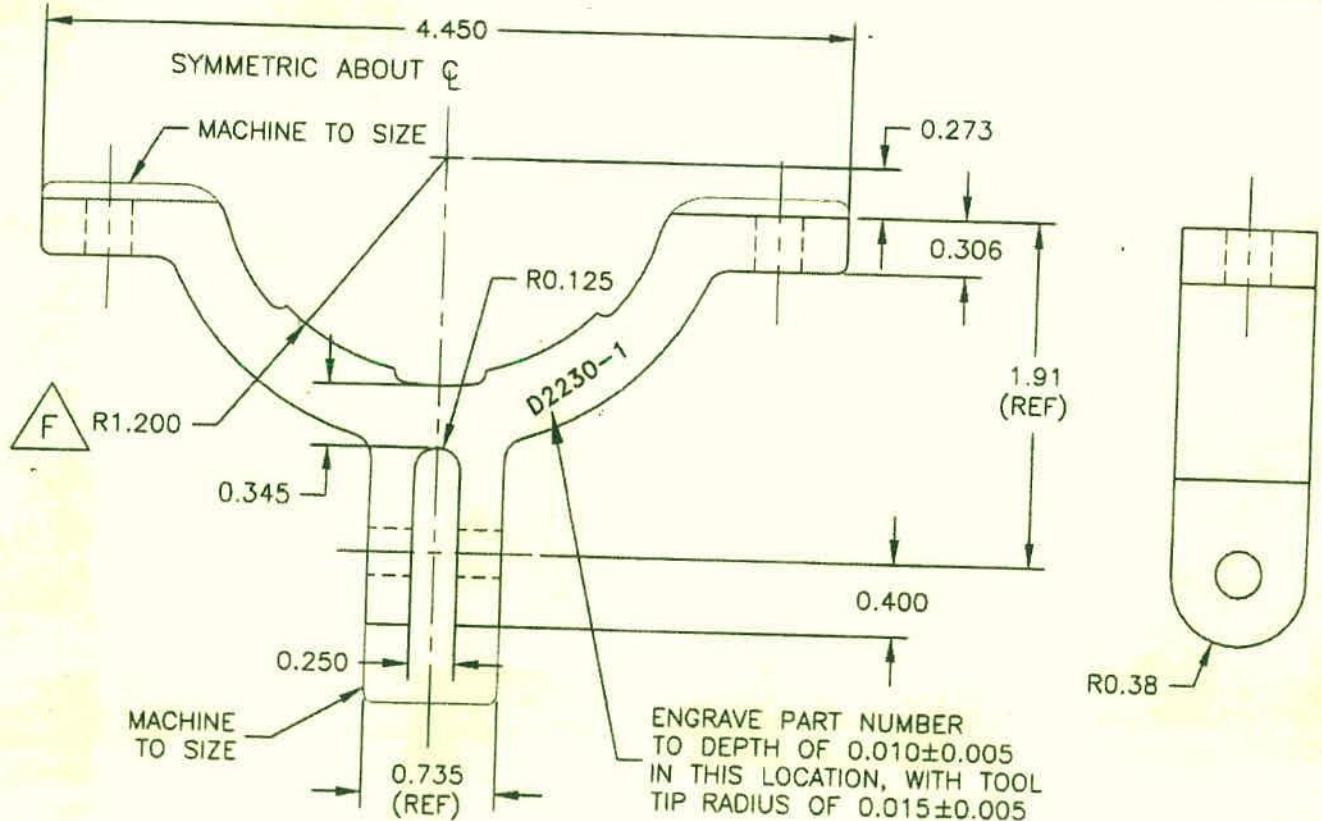


U 07/01/30



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 1 OF 2
99.12.13		TITLE MOUNTING LUG
C	94.03.30	SCALE 1:1
D	95.01.04	
E	95.01.04	
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED  
99.12.21 PS

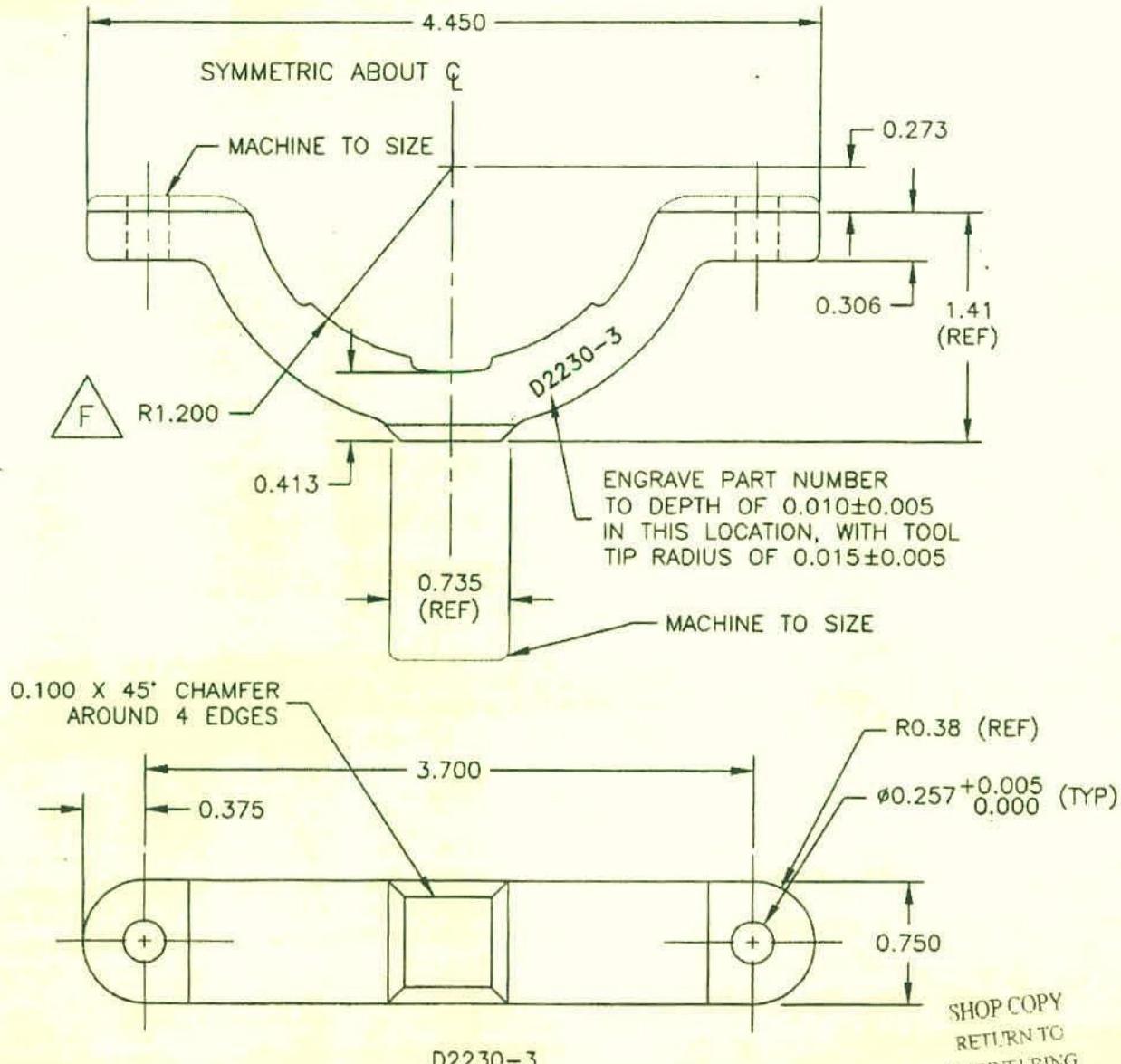
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000–0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29377



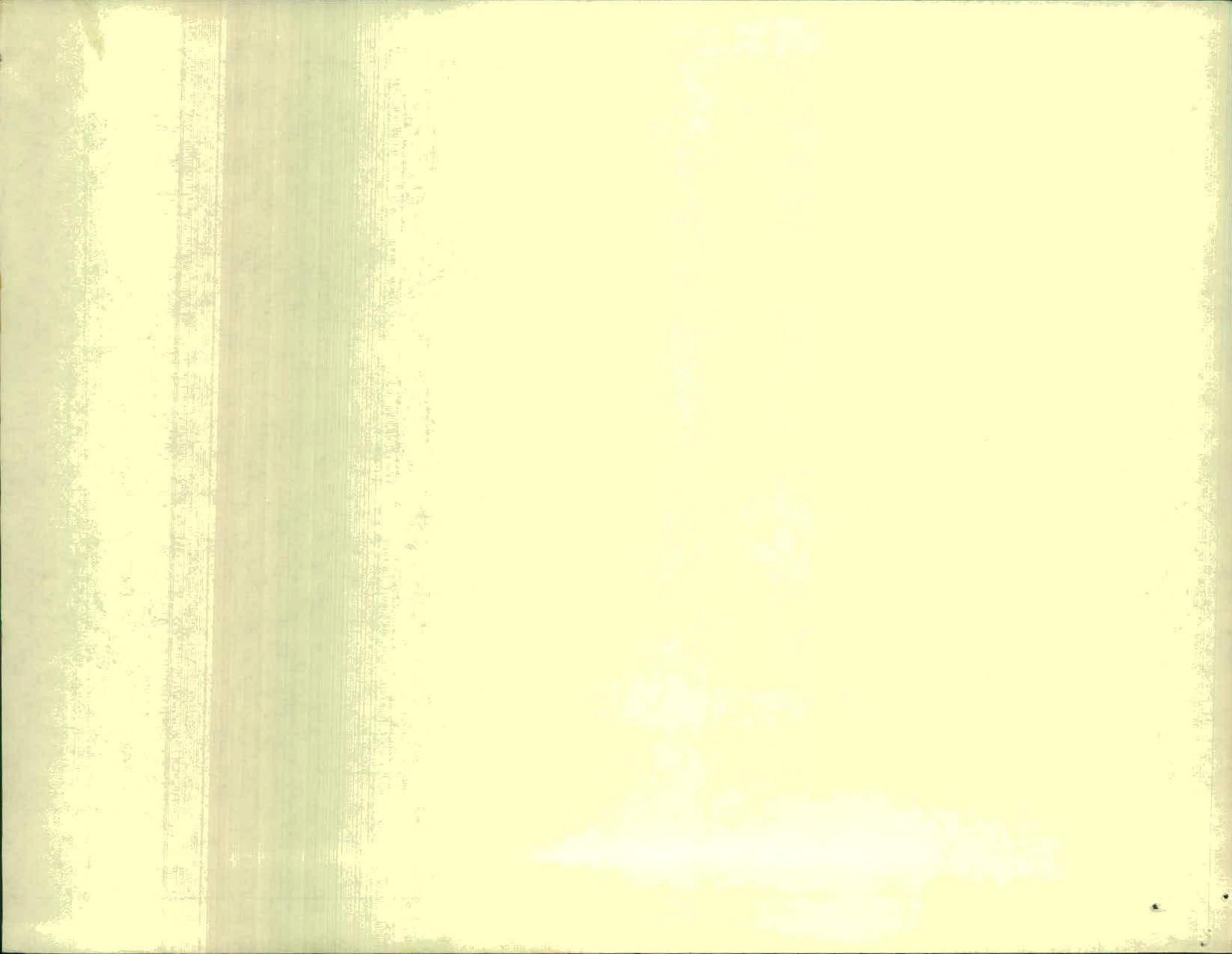
**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE	99.12.13			TITLE MOUNTING LUG SCALE 1:1

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *29377*



# METEC METAL TECHNOLOGY INC

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

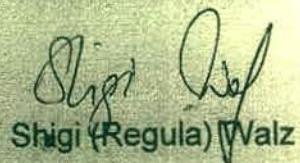
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
125	D2230-1	Lug B29377	2475

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi (Regula) Walz

Vankleek Hill, January 19, 2007

